



DAIKOMCW 107



CARBON STEELS
STRUCTURAL STEEL

DESCRIPTION

All position seamless metal cored wire

Wire designed for welding C and C-Mn steels, including fine grain steels. Virtually spatter free in the spray-arc range. Particularly suitable for robotic applications. It ensures good edge wetting, finely rippled welds, little oxide formation on the weld surface making multipass welding possible without inter-run cleaning. Very good mechanical characteristics and good toughness at low temperature thanks to the very low diffusible hydrogen. Suitable for Argon-CO2 as well as pure CO2 welding

SPECIFICATIONS

ISO 17632-A	T 46 6 M M21 1 H5 / T42 5 M C1 1 H5	AWS A5.36	E71T15-M21A8-CS1-H4 / E71T15-C1A6-CS1-H4
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	M21, C1
Positions	PA, PB, PC, PD, PE, PF, PG	Current	DC+

ASME QUALIFICATIONS	FERRITE	PREN	HARDNESS
F-No (QW432)	6	-	-
A-No (QW442)	1	-	-

CHEM. COMP. %	DEFAULT	MECHANICAL PROPERTIES	MIN	VARIANT
C	0.04	Tensile strength R _m MPa	530	550
Mn	1.4	Yield strength R _{p0.2} MPa	460	460
Ni	0.03	Elongation A (L ₀ =5d ₀) %	20	20
P	0.007	Impact Charpy ISO-V	47J @ -60°C	47J @ -60°C
S	0.009	Impact Charpy ISO-V	-	-
Si	0.6			
Cu	0.12			

WELDING PARAMETERS	1.2 mm	1.6 mm
Ampere	130A - 290A	170A - 400A
Voltage	18V - 30V	28V - 32V
Packaging	Ø 1,0÷1,6mm	Ø 1,0÷1,6mm
Packaging Type	BS300, D200 spools	BS300, D200 spools

V 01/2024



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.





STRUCTURAL STEEL

DESCRIPTION

CARBON STEELS
STRUCTURAL STEEL

APPLICATION

Carbon-manganese (C-Mn) steels serve as the predominant structural steels extensively used across various applications in the engineering industry. Successful welding of C-Mn steel fabrications is generally achievable, provided the steel composition is known, necessary precautions are taken, and qualified procedures are adhered to. Weldability varies among C-Mn steels, with potential cracking mechanisms, including hydrogen cracking, solidification cracking, and reheat cracking, depending on specific circumstances. These consumables effectively resist such issues, emphasizing the importance of a meticulous welding procedure. While preheat and post-weld heat treatment (PWHT) may not be universally required, the actual specifications depend on the grade and thickness of the base material being welded. Attaining the required mechanical properties in a welded joint with C-Mn steels is achievable through the use of appropriate welding consumables. However, the intricate structural changes during the weld thermal cycle necessitate careful evaluation of properties such as heat-affected zone (HAZ) toughness and hardness.

ALLOY TYPE

Consumables for welding mild and C-Mn steels of 340-510MPa tensile strength.

MICROSTRUCTURE

Predominantly ferrite.

MATERIALS

EN W.Nr.: EN AW-Al 99,0 (1200), EN AW-Al 99,7 (1070A), EN AW-Al 99,5 (1050A), EN AW-Al 99,5 (1350), EN AW-Al 99,8 (1080A).

